Work	Orde	er ID	69601

Thursday, May 12, 2011 3:31:56 PM



Page 1

Item ID: D3290-041 Accept Setup Start **Revision ID:** Stop Replacement Window Assembly Item Name: **Start Date:** 5/12/2011 Start Qty: 8.00 **Cust Item ID:** Req'd Qty: 8.00 Required Date: 5/24/2011 **Customer:** Reference: Run Start Date//-15-13 Tooling: Approvals: **Process Plan:** Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Accept Work Center ID Description Qty Code **Qty** Number **Run Hours Draw Nbr Revision Nbr** D3290 DEO Rev C1 100 0.00 FLOW WATER JET 1311-5-17 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3290 (use prog. for D3290-1) Dwg Rev: 6061.063 Prog Rev: C 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 13(1-5-17 QC 0.00 Memo Quality Control

120

QC8- Inspect parts - second check

Memo

0.00

0 1005/18

Quality Control

Reject

Insp. Stamp

	-								-
W/O:			We	RK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	<u> </u>	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C C	losed:		Date:	
NCR:			MANCE (NC	R)					
DATE	STEP	Description of NC			ection B	Verifica	ation	Approval	Approval
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Work Order ID 69601

Thursday, May 12, 2011 3:31:56 PM



Page 2

Item ID:

D3290-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 5/24/2011

Replacement Window Assembly

Start Date:

5/12/2011

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

130

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Tool ID

Tool # Plan Code Accept Reject Qty

Qty

Reject Number

Insp. Stamp

140

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M 116 964.

Memo

0.00

0.00

FINISH TIME:

11111

BL 11-5-19

150

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

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W/O:			V	ORK ORDER CHANG	ES	• • • • • • • • • • • • • • • • • • • •			*
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DG	 A:	Date: _	<u> </u>
		esolution:							
NCR:	,	W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Secti Action Description Chief Eng	on B Sign Date	& Sec	ication tion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 69601

Thursday, May 12, 2011 3:31:57 PM



Page 3

Item ID:

D3290-041

Accept

1

Setup Start



Revision ID:

Item Name:

Required Date: 5/24/2011

Replacement Window Assembly

Start Date:

5/12/2011

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC: Date:

Memo

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

Small Fab

Small Fab

Operation **Description**

Small Fab

Set Up/ **Run Hours**

0.00

0.00

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

170

Quality Control

QC5- Inspect part completeness to step on W/O

180

Packaging

Identify as per dwg & Stock Location.

0.00

Memo

Memo

0.00

Packaging

W/O:			W	ORK ORDER CHANG	SES					• •
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	_ NCR:	Yes N	lo DQ	A:	_ Date: _	
	R	esolution:							Date:	
NCR:		V	WORK ORDER NON-CONFORM							
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Initial Action Description			Verification Section C		Approval Chief Eng	Approval QC Inspector
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W	ork	Ord	er ID	69	601
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Thursday, May 12, 2011 3:31:57 PM



Page 4

Item ID:

D3290-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Window Assembly

Start Date:

5/12/2011

Start Qty: 8.00

Required Date: 5/24/2011

Req'd Qty: 8.00



Cust Item ID: Customer:

Tool ID

Reference:

An	provals:	
711	pi o rais.	

Process Plan: Date:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Tool # Plan

Code

Date:

Run

Start

Stop

Stop

Sequence ID/

Work Center ID

190

QC Quality Control Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

0.00

Reject Accept Qty

Qty

Reject Insp.

Number, Stamp

Memo

W/O:			V	ORK ORDER CH	ANGES					t
DATE	STEP	PROC	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
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DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &		cation		Approval
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Picklist Print

Thursday, May 12, 2011 3:32:04 PM

Work Order ID: 69601

Parent Item:

D3290-041

Parent Item Name: Replacement Window Assembly



Start Date: 5/12/2011

Required Date: 5/24/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP B□05.05.25□Added Step 11□KJ/JLM□

IPP C□06.05.09□Ecn 798

IPP Rev:D Now on Waterjet 06-06-16 JLM

07.09.28 FC verified by: DD

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
46061T6S.063	##	Purchased	No			100	sf	320.5000	3.75	31.5789	RI+-2-1	17	
				<u>Location</u>		Loc	<u>Qty</u>	Loc Code					
				MAT021			320.5		_		_	Q\	
					116308		32.5		_		_	(8)	
					117285		288		<u>.</u>	17785	_		
02126		Manufactured	No			160	f	564.2586	6.5	52			
													19
eal													
				Location		Loc	<u>Otv</u>	Loc Code					11/07/
•				ST405		564	.2586				_		17
					57106		4		_				
					64918	60	.2586		_		_		
				<	68336		500		_	_52_	_		

D3290-3

Window

No Manufactured

0.0000 Each

8

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W/O:			W	ORK ORDI	ER CHANG	ES					<u></u> •
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	(Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							B. B. C.				
Part No	:	PAR #:	Fault Cat	egory:		NCR: Y	es No	DQA	\:	_ Date: _	
	Re	esolution:	Dispositi	on:		_ QA: N/C	Clos	ed:		Date: _	
NCR:			NCE (N	CR)							
DATE	STEP	Description of NC		Corrective			0	Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng		Description Chief Eng		ın & ate	Section	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	69601
Description: Window Frame	Part Number:	D3290-1
Inspection Dwg: D3290 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

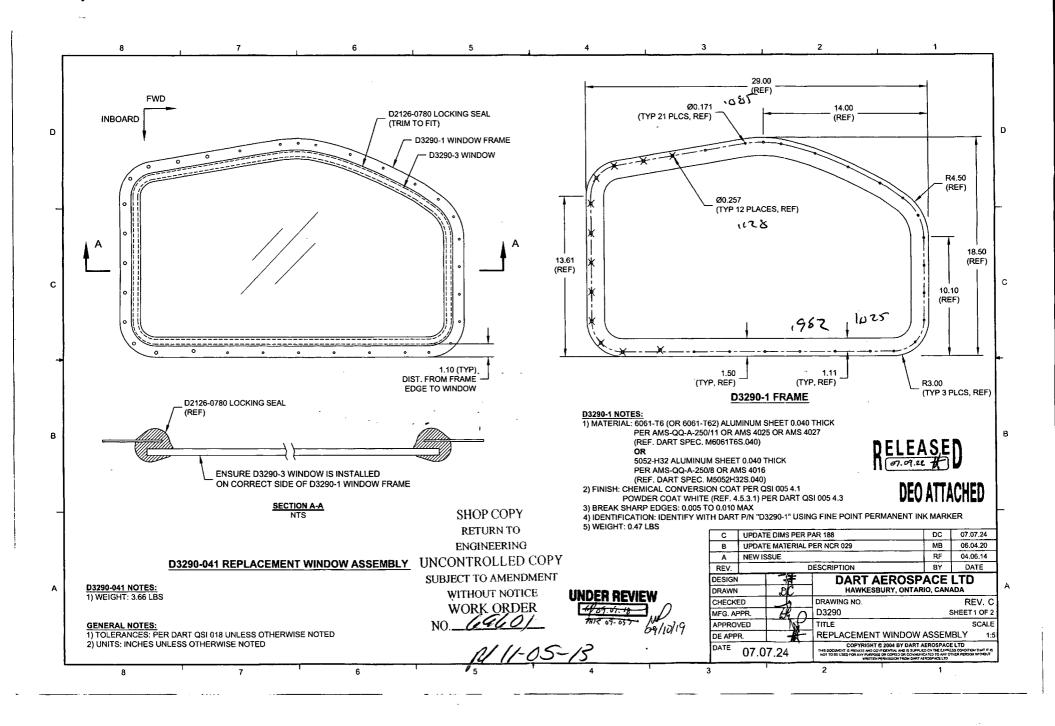
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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14.00	+/-0.030	14,00	<u></u>		7	
Ø0.171	+0.005/-0.001	้า3	8		V	
1.50	+/-0.030	1.506	>		V	
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10.10	+/-0.030	10.10	4		7	
18.50	+/-0.030	18.50	8		7	
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R3.00	+/-0.030	3,00	b		RG.	
R4.50	+/-0.030	4.50	>		RG.	·.
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13.61	+/-0.030	13.61	7		7	
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Measured by: இ	Audited by:	Prototype Approval:	N/A
Date: 11-4-17	Date: Willy (8	Date:	N/A

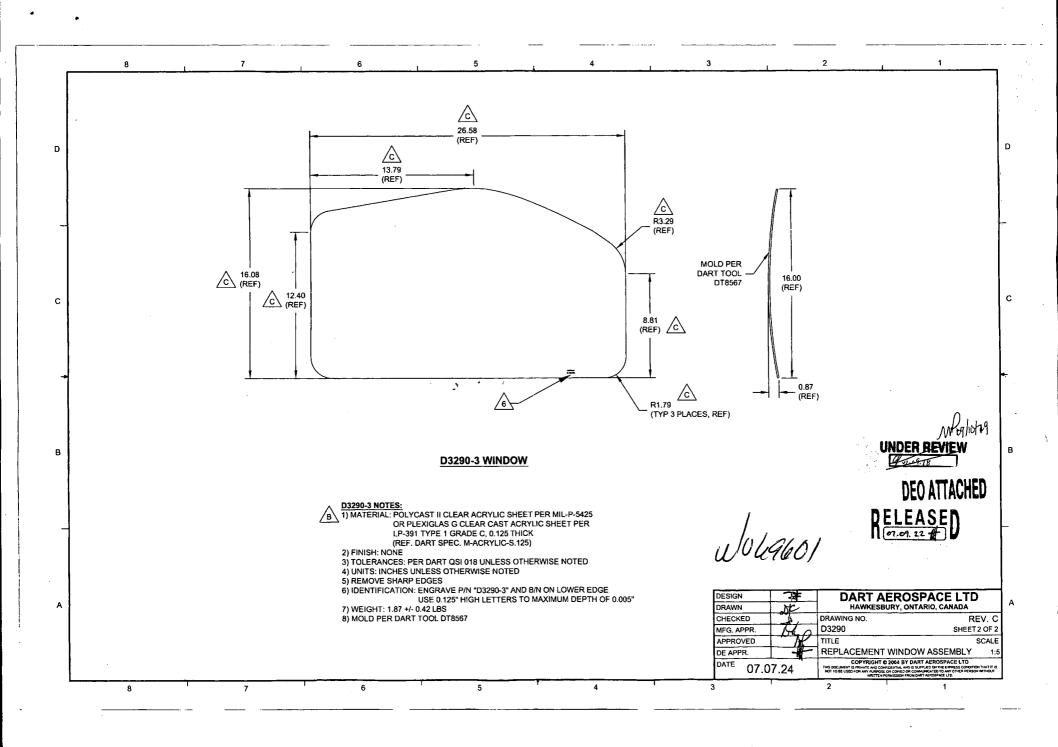
Rev	Date	Change		Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	*	KJ/JLM	
В	07.07.18	13.61 dimension removed		KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C		KJ/EC/DD _↑	44
D	09.11.04	Dimension 0.063 was 0.040		KJ KJ	

Dart Aerospace	Ltd	
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W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA: _	Date: _	
Resolution:			Dispositio	n:	_ QA: N/C CI	osed:	Date: _	
NCR:		·	WORK ORD	ER NON-CONFORMA	NCE (NCF	R)		
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W/O: DATE STEP			W	ORK ORDER CHANG	ES					
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Part No:		PAR #:	Fault Cate	egory:	_ NCF	l: Yes N	lo DQA	\:	Date:	
Resolution:										
NCR:		· ·	WORK ORD	ER NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval
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W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE By Date Qty Chief Eng Prod Mg							Approval QC Inspector				
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Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:						
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DAIE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector				
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DRAWING	NO.	TITLE		REV. C	DART AE	ROSPACE LTD	D.E.O. NO.		SHEET NO.	SCALE
D3290		REPLACEME	ENT WINDO	OW ASSEMBLY	ENGINE	ERING ORDER	D3290-C-1	_	SHEET 1 OF 1	NTS
DRAWN	9		CHECKED	.ls	MFG. APPR.	E.	APPROVED /	9	DE APPR.	
DATE	09.09.1	18	DATE (×1.09.18	DATE	69.09.18	DATE 09/09/	2).	DATE 09/09/	21

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK (REPLACE)

PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027

(REF. DART-SPEC. M6061T6S.040)- REF. DART SPEC. M6061T6S.063 (REPLACE)

OR

5052-H32 ALUMINUM SHEET 0.040-THICK (REPLACE)

PER AMS-QQ-A-250/8 OR AMS 4016

(REF. DART-SPEC. M5052H32S.040) REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED 2009 -10- 0 9

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HOTTO BE USED FOR ANY PURPOSE OR COMPLETE TO THE OTHER PERSONMENDATION.

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Part No:		PAR #:	_ Fault Ca	tegory:		_ NCF	R: Yes N	o DQA:		Date:		
	R	esolution:	Disposition: Q				N/C Clos	sed:		Date:		
NCR:		W	ORK OR	DER NON-	CONFORM	ANCE	(NCR)			*.		
DATE	STEP	Description of NC	Corrective Action Section B			tion B	Verification			Approval	Approval	
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